

Process Sheet

Dart Helicopters Services

Split 302-12-12

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM	
Job Number	: 35298 <i>2</i>			Part Number	: D3560044	
Estimate Number	: 12884			Drawing Number	: D3560 UNDER REVIEW	
P.O. Number	:			Project Number	: N/A	
This Issue	: 22/10/2007 S.O. No. :			Drawing Revision	: C	
Prsht Rev.	: NC			Material	:	
First Issue	: 11 Type : SMALL /MED FAB			Due Date	: 29/10/2007	
Previous Run	: 35032			Qty:	14 Um: Each	
Written By	:			<i>2</i>		
Checked & Approved By	:			<i>2</i>		
Comment	Est Rev:A	New Issue	07.05.24	EC		
	Est Rev B	ECN 987	07.10.09	EC	verified by DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
	Comment: Qty.: 1.3598 f(s)/Unit Total : 19.0365 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: 7106132	<i>OK 07/11/30</i>
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks 15.500" long	<i>OK 07/11/30</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	1- Mill as per Folio FA696 Rev: <u>11</u> & Dwg D3560 Rev: <u>C</u> 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560	<i>OK 07/11/08 S.P. 07/12/07</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>OK 07/11/08 S.P. 07/12/07</i>
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<i>OK 07/12/07</i>

Date: Monday, 22/10/2007 2:17:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35298

Part Number: D3560044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D35921 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

B41C83 ✓

SP 08-09-02 (72)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch () SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

(PD) →

SP 08-09-02

(72)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Co8/09/05 (72)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-05 (72)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-09-08

(72)

Date: Monday, 22/10/2007 2:17:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35298

Part Number: D3560044

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0 D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 14.0000 Each(s)

Spacer batch: B37113

13.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

14.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

Pat E.
Sodolos ④

16.0 QC21

FINAL INSPECTION/W/O RELEASE

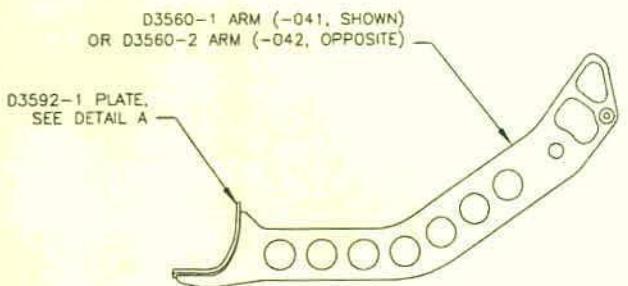


Comment: FINAL INSPECTION/W/O RELEASE

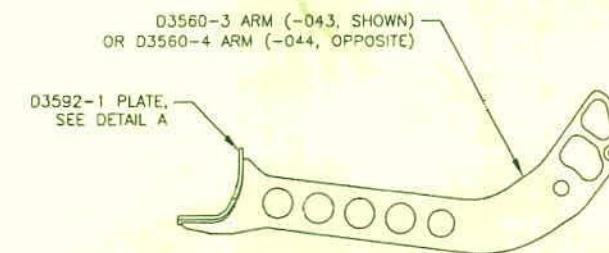
Job Completion



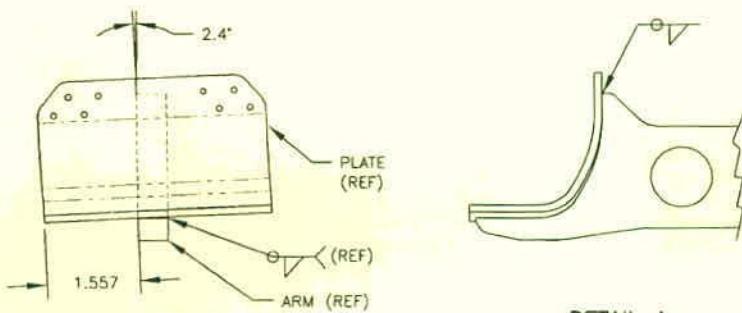
mf 08-09-09



D3560-041 ARM WELDMENT (SHOWN)
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN)
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

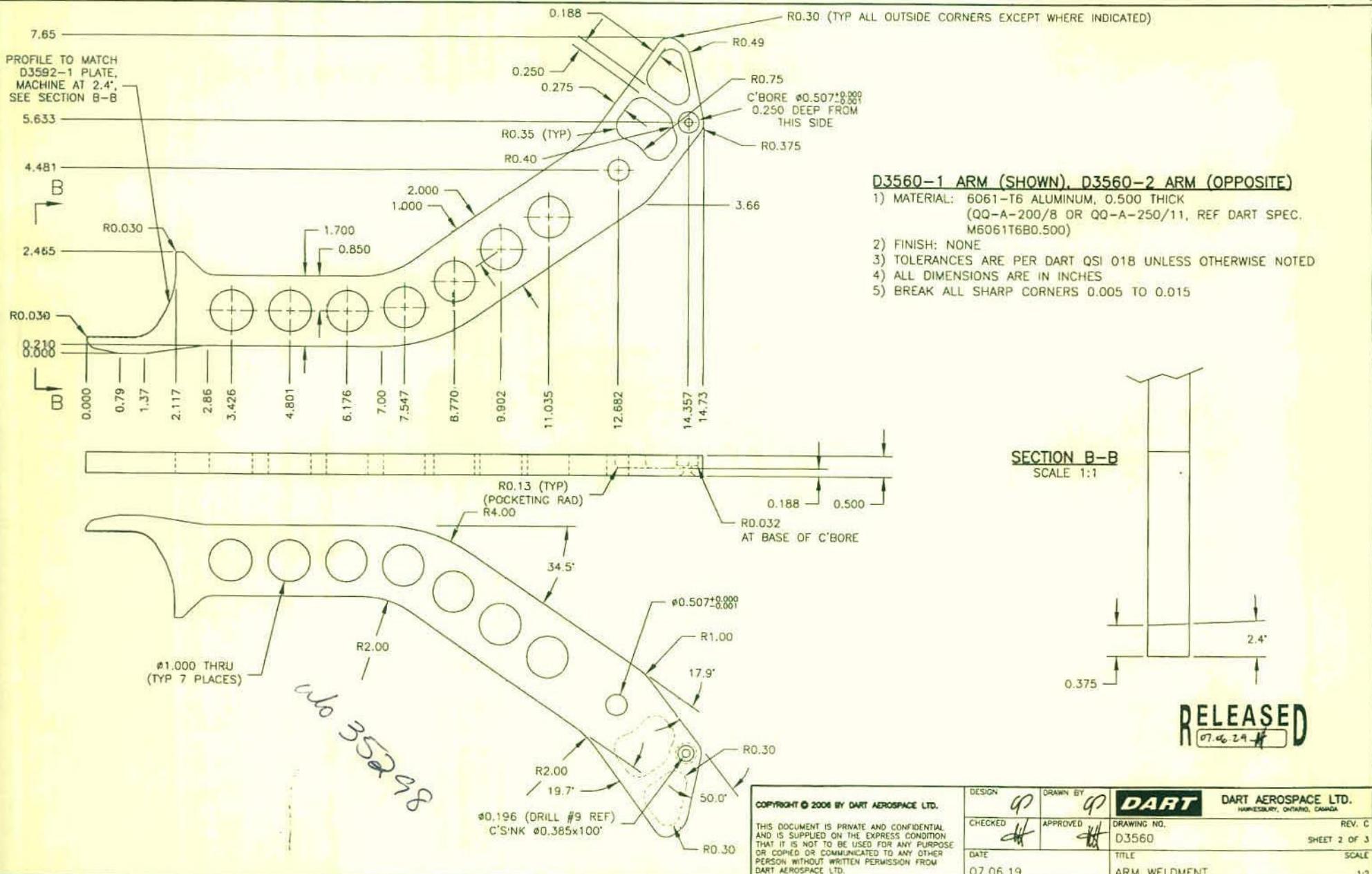
- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
 07.06.19
 UNDER REVIEW
 07.10.22 DC

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART
07	07	DART AEROSPACE LTD. HARVESSARY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
07	07	REV. C SHEET 1 OF 3
DATE	TITLE	SCALE
07.06.19	ARM WELDMENT	1:4

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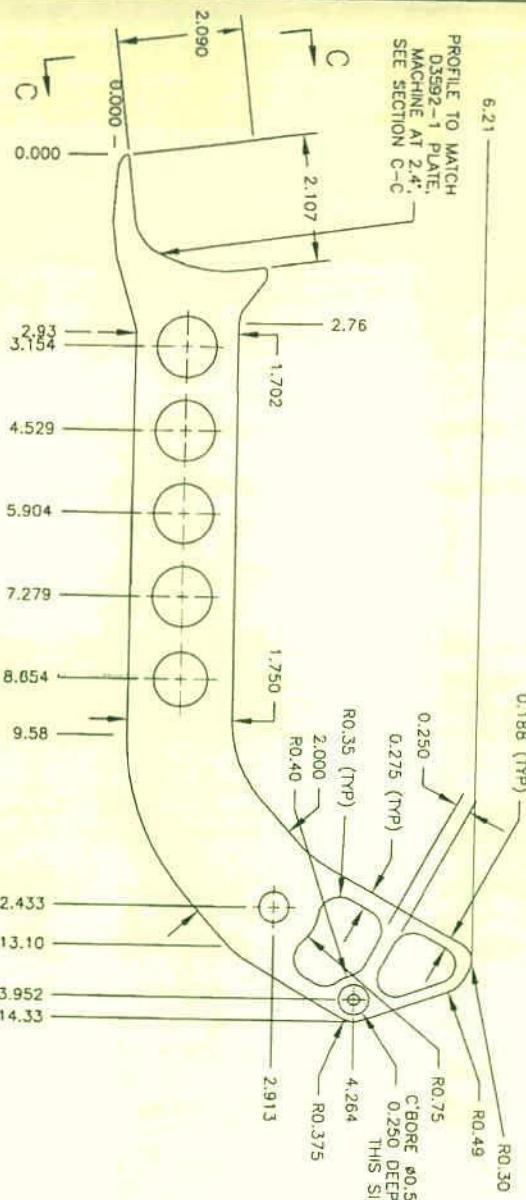


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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
9	9	9	REV. C
CHECKED	APPROVED	9	DRAWING NO.
			D3560
DATE			SHEET 2 OF 3
07.06.19			SCALE
			ARM WELDMENT
			1:2

6.2

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4'.
SEE SECTION C-C.



D3560-3 ARM (SHOWN). D3560-4 ARM (OPPOSITE)

6061-T6 ALUMINUM, 0.500 THICK
(00-A-200/8 OR QQ-A-250/11
M6061T6B0.500)

REF DART SPEC.

2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

5. OTHERWISE NOTED

SECTION C-C
VIEW ROTATED
SCALE 1:1

A diagram of a stepped rectangular block. The vertical height is labeled as 0.375. The horizontal width is labeled as 2.4. The block is shown in three segments: a top horizontal bar, a middle rectangular box, and a bottom horizontal bar.

RELEASER
07.06.29
#

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DESIGN	
CHECKED	APPROVED
DATE	
07-06-19	
DRAWN BY	
DRAFT	
DRAFT AEROSPACE LTD.	
WATERLOO, ONTARIO, CANADA	
DRAWING NO.	
D3560	
TITLE	
ARM WELDMENT	
SHEET 3 OF 3	
SCALE	
1:2	

DART AEROSPACE LTD	Work Order:	35290
Description: Arm	Part Number:	D3560-4
Inspection Dwg: D3560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: JF
Date: 07/12/07

Audited by: Onf
Date: 07/13/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	

